

Date: Monday, 2/27/2006 1:27:45 PM
 User: Linda Lacelle

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING ASSEMBLY
Job Number	: 25940		
Estimate Number	: 10181		
P.O. Number	: N/A	Part Number	: D2153
This Issue	: 2/27/2006 S.O. No. : N/A	Drawing Number	: D2153 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A1
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/6/2006 Qty: 36 Um: Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est: E 02.07.08 Re-format KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 60000668

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

2.0	D2153P SL13-10	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 36.0000 Each(s)
 GAS SPRING ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

4/3/6 (36)
 060306 36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 1:27:45 PM
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Drawing Name: GAS SPRING ASSEMBLY

Job Number: 25940

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Lock Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 72.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

B25149
B23096

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 72.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

M18100

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 72.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

M16943

SB 06/03/15 (4)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

SB 06/03/15 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-15 4

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST218*

C 06/03/15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 06/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25940

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/03/15 (4)

Job Completion



u 06/03.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

attwood®

SWIVLE-EZE

TELEPHONE: 816-877-2270

CUST: 58580 MST: 06244 00

PKG=PR/A TRK=COL

BILL NO: 442 88871

SHIP VIA: UPS GROUND

FREIGHT: _____

BILL TO: DART AERO LTD.
REQ: 03/01/06

ATTWOOD / SWIVLE-EZE

1016 NORTH MONROE
LOWELL

MI 49331-0280

DART AERO LTD.
1270 ABERDEEN STREET

HAMPSHIRE ON K6A 1K7

DATE: 1 PO# 668

NOT: 12 DATE: 02/28/06

SPUR: 9

LABEL NO:
0609390001

---ROUTING GUIDE INFO---

---SHIPPED---						ORDER			
QTY	QTY	LOCATN	WM	PART# / UPC	DESCRIPTION / SKU	LINE	QTY	QTY	QTY
1	36	Z03541	EA	SL13-10-1	GS SPRNG 15" EXTC 104 SL	1	36	1	1

P.O. 668

COMMERCIAL INVOICE

Page: 1

FROM		
Tax ID: 364308711 Contact Name: Trisha Smith Attwood Corporation 1016 N Monroe Lowell MI 49331 UNITED STATES Phone: 616 897-9241		
SHIP TO		
Tax ID: Contact Name: DART AERO LTD. 1270 ABERDEEN STREET HAWKESBURY ON K6A 1K7 CANADA Phone: 613-632-3336		

Shipment ID: 4545743FVJM	
@4545743FVJM.a Invoice No: 3835390001 Date: 28/FEB/2006 PO No: Terms of Sale (Incoterm): FOB Reason for Export: Sale	
SOLD TO INFORMATION	
Tax ID: Contact Name: DART AERO LTD. 1270 ABERDEEN STREET HAWKESBURY ON K6A 1K7 Phone: 613-632-3336	

Units	U/M	Description of Goods	Harm. Code	C/O	Unit Value	Total Value
36 EA		SL13-10-1 GAS SPRING 15" EXTC 10# BL SCKT	8302.49.6035	NZ	7.640000	275.04

Additional Comments:

Declaration Statement:

I HEREBY CERTIFY THAT THE INFORMATION ON THIS INVOICE IS TRUE AND CORRECT AND THE CONTENTS AND VALUE OF THIS SHIPMENT IS AS STATED ABOVE.

Shipper

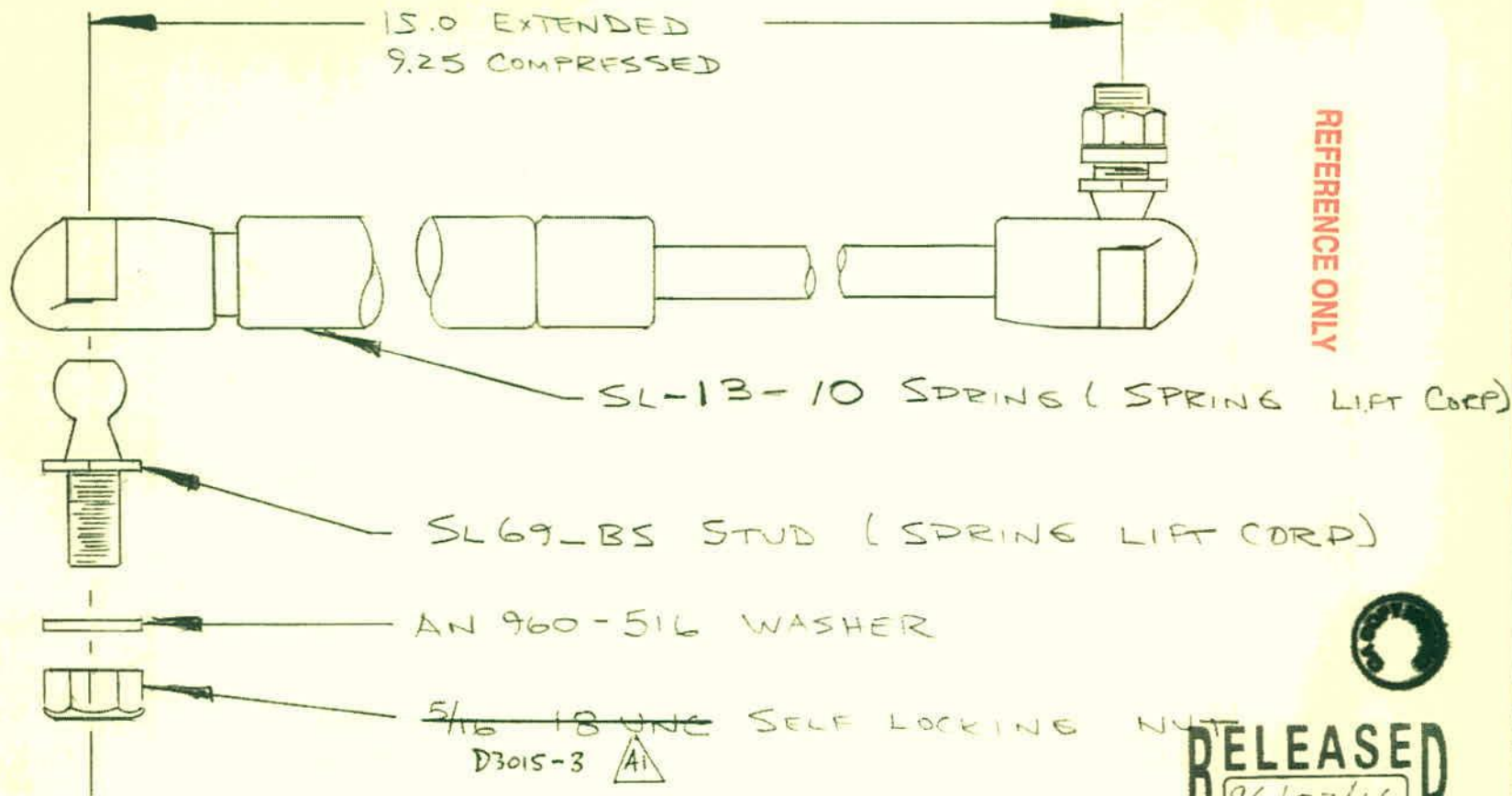
Date

02/28/2006

Invoice Line Total:	275.04
Discount/Rebate:	0.00
Invoice Sub-total:	275.04
Freight:	16.85
Insurance:	0.00
Other:	0.00
Total Invoice Amount:	291.89

Total Number of Packages:	1	Currency: USD
Total Weight:	11.60	Lbs.

THESE COMMODITIES, TECHNOLOGY OR SOFTWARE WERE EXPORTED FROM THE UNITED STATES IN ACCORDANCE WITH THE EXPORT ADMINISTRATION REGULATIONS. DIVERSION CONTRARY TO U.S. LAW PROHIBITED.



RELEASED
96/07/16

AI	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
AI	A	DRAWN			BASIC CODE		CONTRACT NO		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
AI	A	APPROVED			D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK		DATE 07.28.72				
AI	A	DESCRIPTION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		DRAWN HATTON		TITLE GAS SPRING ASSEMBLY		
AI	A	OF	GENERAL		LIMITS		DESIGN HATTON		CODE		
AI	A	CHANGE	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 400 3. REMOVE SHARP EDGES .015 MAX 4. THREDS PER INCH - 5 - 3142 5. HOLES PER AND 10287		1. TOLERANCES — XX ± .030 2. ANGLES XXX ± .010 3. PARALLELISM .0075 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MTC CENTRE LINES .005		CHECKED HATTON		DWG NO DZ153		
			REPORT ALL DISCREPANCIES — DO NOT SCALE				CLIN		REV A		

102153

